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LC 0148 PUS

In the Specification

[0028] Figures 2 through 5 illustrate a preferred process in accordance with the present invention. As shown in Figure 2, the mold 10 is first closed and clamped together in a conventional manner. The seals 36, 38 provide a sealed mold so that pressure cannot escape from it. Initially, the pressure in the mold is energized to a pressure of P1. The pressure is a pre-established pressure setting on the gas pressure valve 40 as controlled by pressure switch 41. Gas from gas source 33 is injected through the valve 46, conduit 48 and conduit 42 into the mold cavity 18. This is shown by arrow 52. The value of pressure P1 is preestablished by the parameters of the injection molding process, including factors such as the amount of material to be utilized, the size of the part and the melt index.